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**Date:**

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0.00

Prog Rev: \_\_\_\_\_

QC2- Inspect parts off machine FAI/FAIB

\_\_\_\_\_

0.00

1B 9-12-16

①

1B 9-12-16

**Work Order ID 54686**

December 16, 2009 10:46:26 AM



Page 2

Item ID: D3891-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Fwd RH

Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2&gt; S 01/12/16

130

0.00



Small Fab

Memo

0.00

Small Fab

Deburr if necessary

9/30/12/17 ①

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SB 09/12/17 ①

# Work Order ID 54686

December 16, 2009 10:46:26 AM



Page 3

Item ID: D3891-042

Accept



Setup Start



Revision ID:

Item Name: Panel, Fwd RH

Stop



Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

0.00



Small Fab

Memo

0.00

Small Fab

I- Bond gasket to smooth side of panel as per dwg  
A/R 3M 1300 adhesive Batch: 17113174

8/20/12/17 @

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 Dec 12/18

(X)

170

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

SLAN  
HAI

9/12/18 SPD

**Work Order ID 54686**

December 16, 2009 10:46:27 AM



Page 4

Item ID: D3891-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Fwd RH

Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/21

PL 09-12-18

# Picklist Print

December 16, 2009 10:46:25 AM

Page 1

Work Order ID: 54686

Parent Item: D3891-042

Parent Item Name: Panel, Fwd RH



Start Date: 12/16/09

Required Date: 12/18/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 		Purchased	No			100	sf	2,011.175	4.0102			
GE PLASTICS LEXAN SHEET												B 9-12-11

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

2011.175198

103106

1.6765

105330

47.8767

109455

40.5717

111710

329.893632

112585

1591.15667

D3891-4

Manufactured

No

140

Each

0.0000

1.0000



Gasket

B 54490

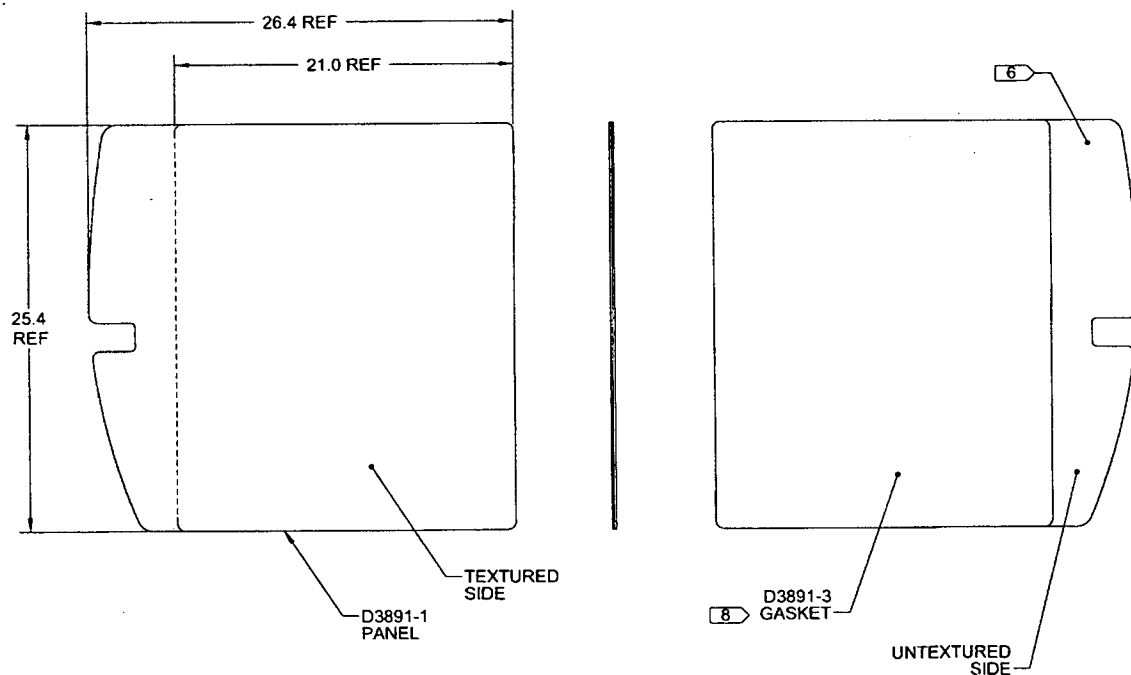
112585

50 09/12/17 ①



## PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE

**D3891-041 PANEL, FWD LH**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: NONE
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
  - 7) WEIGHT: 3.67 lbs
  - 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34684

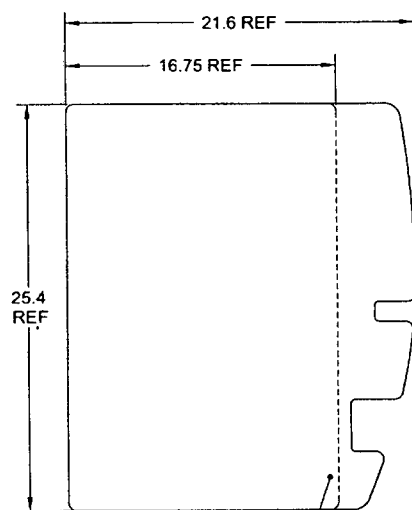
*BL09-12-16*

**RELEASED**  
C9/06/16 NTS

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>GP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>GP</i>		
CHECKED	<i>RP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JP</i>	D3891	SHEET 1 OF 6
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	PANEL, FWD	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

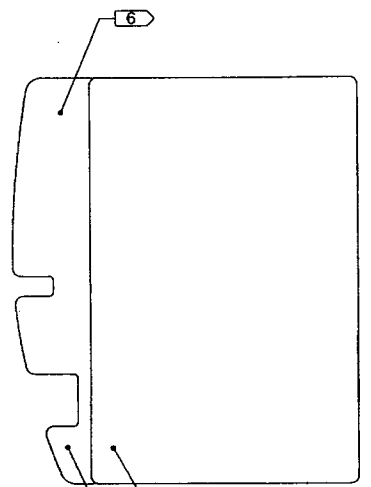
## PARTS LIST

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D3891-042	PANEL, FWD RH
2	1	D3891-2	PANEL
3	1	D3891-4	GASKET
4	A/R	3M 1300	ADHESIVE

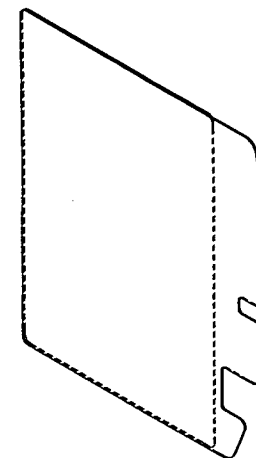


D3891-2 PANEL

TEXTURED SIDE

**D3891-042 PANEL, FWD RH**

D3891-4 GASKET 8

UNTEXTURED  
SIDE

## NOTES:

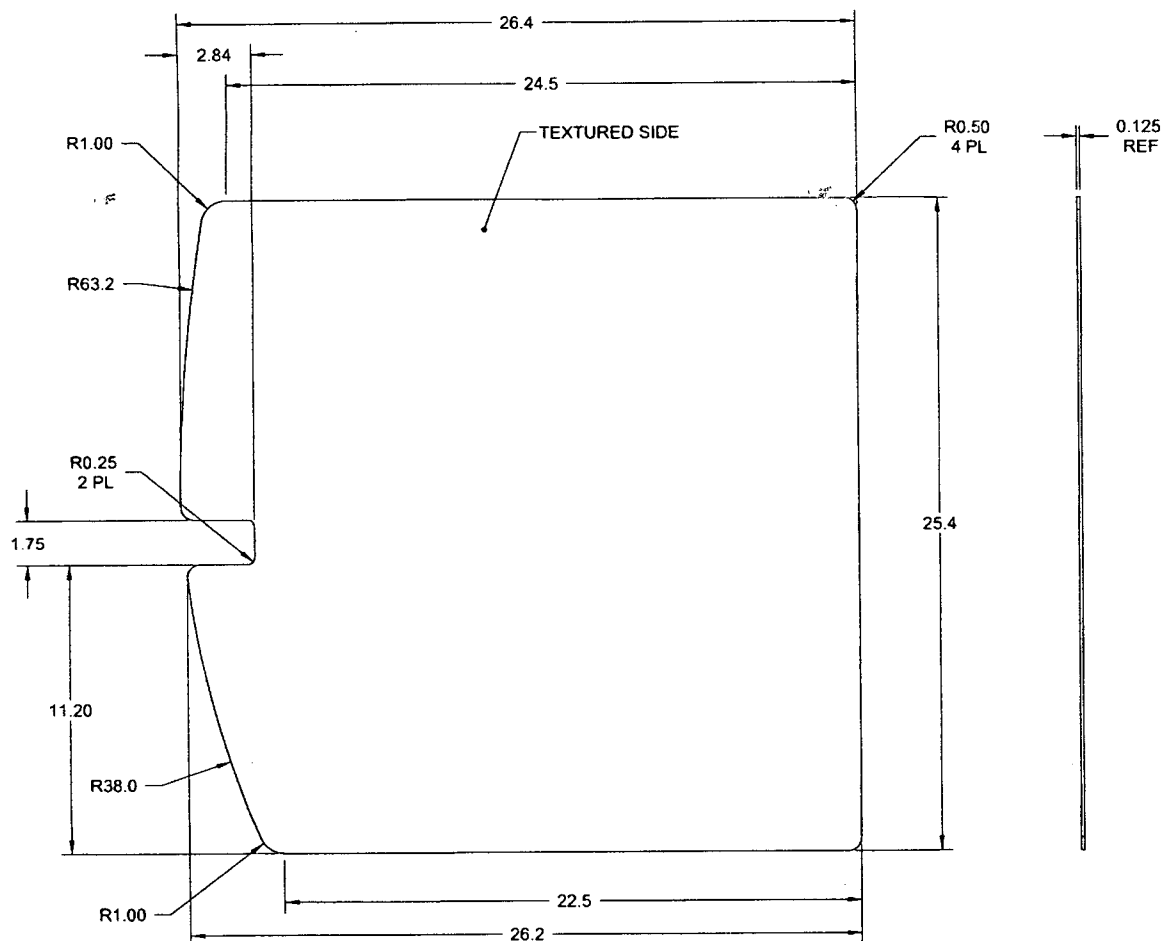
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.93 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

RELEASED  
09/05/01

DESIGN	gp	DART AEROSPACE LTD	
DRAWN	gp	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RL	DRAWING NO.	REV. A
MFG. APPR.	SL	D3891	SHEET 2 OF 6
APPROVED	SL	TITLE	SCALE
DE APPR.	SL	PANEL, FWD	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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W/O 54686





**D3891-1 PANEL**

**NOTES:**

1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

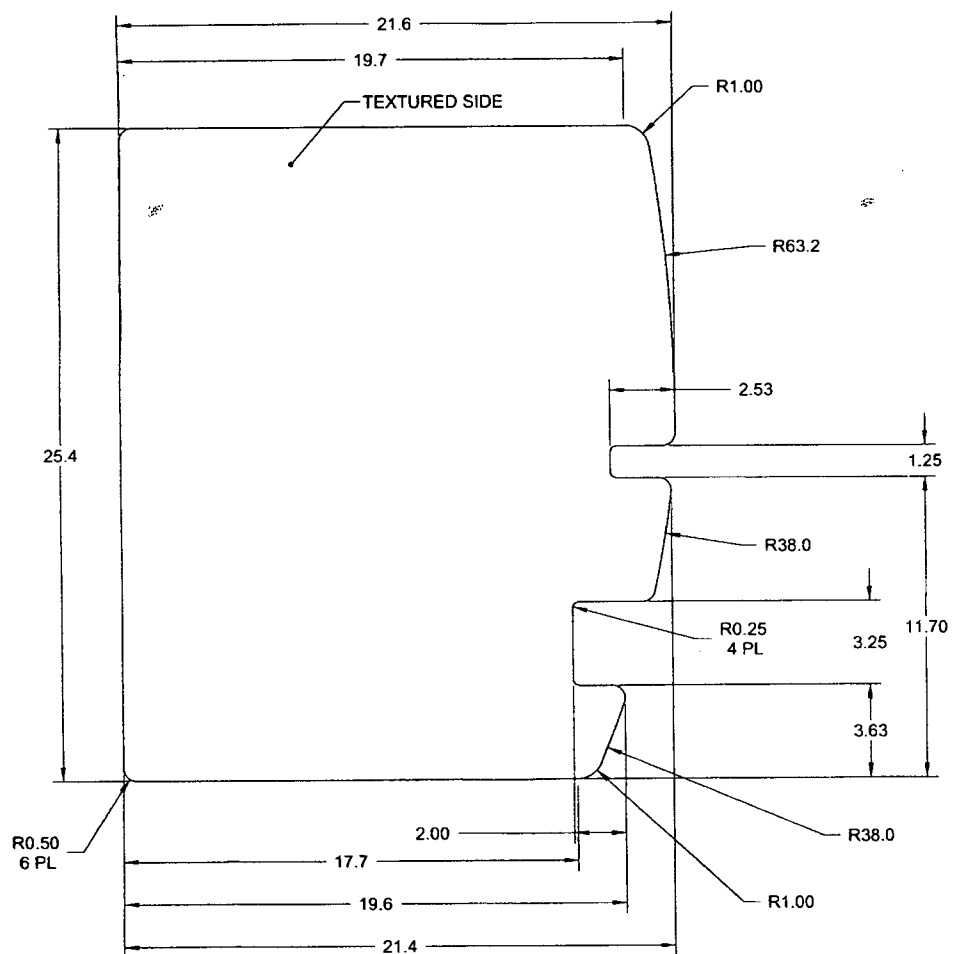
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 3.46 lbs

**RELEASED**  
07/16/16

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.		D3891	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		PANEL, FWD	NTS
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**D3891-2 PANEL**

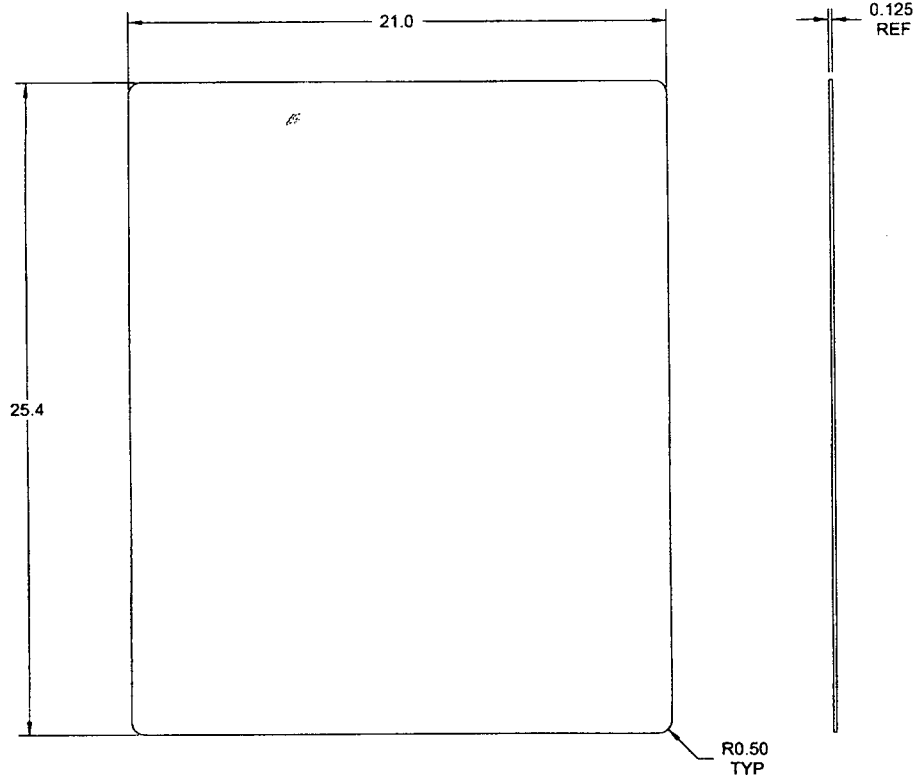
**NOTES:**

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.77 lbs

**RELEASED**  
09/05/10

DESIGN	DP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3891</b> TITLE <b>PANEL, FWD</b> COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>
DRAWN	DP	
CHECKED	AS	
MFG. APPR.	SWP	
APPROVED	SWP	
DE APPR.	SWP	REV. A
DATE	09.05.01	SHEET 4 OF 6
		SCALE NTS

W1054686



**D3891-3 GASKET**

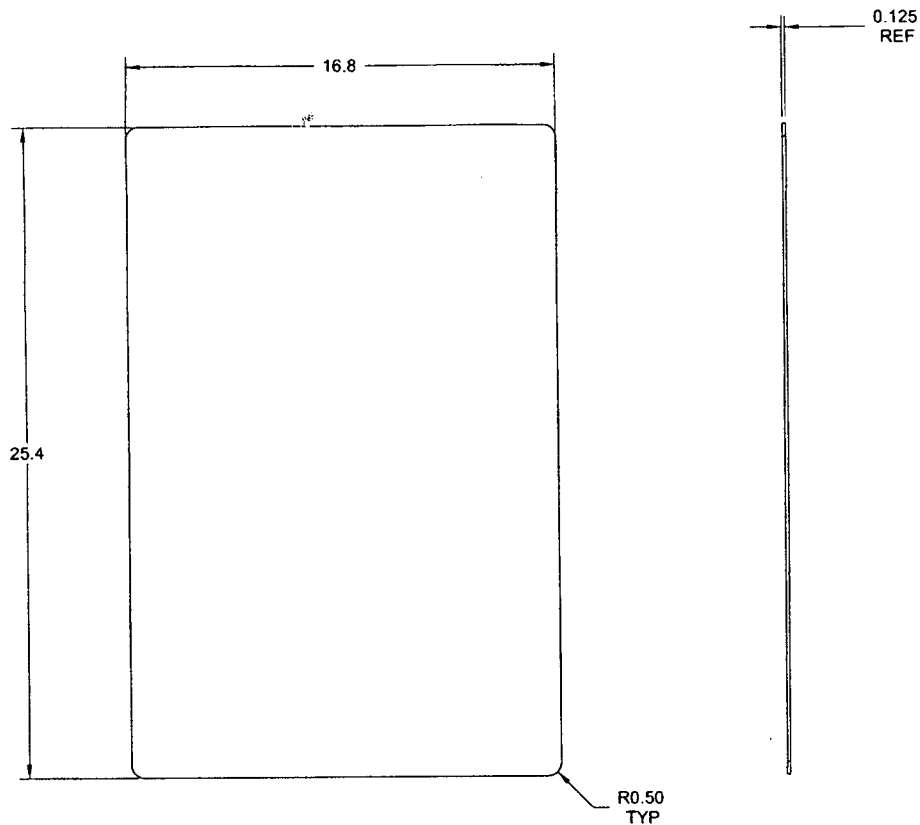
**NOTES:**

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK  
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.21 lbs

DESIGN	92	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3891</b> REV. A SHEET 5 OF 6 TITLE <b>PANEL, FWD</b> SCALE NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>
DRAWN	92	
CHECKED	92	
MFG. APPR.	92	
APPROVED	92	
DE APPR.	92	
DATE	09.05.01	

**RELEASED**  
09/05/01

W1034286



**D3891-4 GASKET**

**RELEASED**  
09/08/16-48

*w/054686*

- NOTES:**  
 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK  
 (REF DART SPEC. M4111N-S.125)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: NONE  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 0.17 lbs

DESIGN	qp	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	qp		
CHECKED	pa	DRAWING NO.	REV. A
MFG. APPR.	[Signature]	D3891	SHEET 6 OF 6
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	PANEL, FWD	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	